The extrusion material is melt-kneaded in the extruder 100 into a melt, which then enters a circular die 140. The circular die 140 is provided with a gas inlet passage 150. Through the gas inlet passage 150, a gas is blown into the circular die 140, whereupon the melt having passed through the circular die 140 in a tubular form inflates while scaling up in the diametrical direction. Since the diameter is enlarged, this extrusion is called blown-film extrusion (i.e., inflation). The blown-film extrusion enables extrusion into thin films with ease, and is also readily achievable of an improvement in strength attributable to changes in orientation of resin, called a stretch effect. Thus, this is particularly preferred as a production process used in the present invention.

The gas to be blown here may be selected from air, nitrogen, carbon dioxide and argon. The extruded product having thus inflated into a cylinder is drawn upward while being cooled by a cooling ring 160. At this stage, the extruded product passes through the space defined by a dimension stabilizing guide 170, so that its final shape and dimensions are determined. This product is further cut in desired width, thus a seamless endless belt 190 of the present invention can be obtained.

The foregoing description relates to a single-layer belt. In the case of the endless belt of

double-layer configuration, an extruder 110 is additionally provided as shown in Fig. 3. Simultaneously with the kneaded melt held in the extruder 100, a kneaded melt in the extruder 110 is sent to a double-layer circular die 140, and the two layers are scale-up inflated simultaneously, thus a double-layer belt can be obtained.

In the case of triple- or more layers, the extruder may be provided in the number corresponding to the number of layers. Examples of the endless belt of double-layer configuration consisting of a first layer 201 and a second layer 202 and that of triple-layer configuration consisting of a first layer 201, a second layer 202 and a third layer 203 are shown in Fig. 4, and Figs. 5 and 6, respectively. Thus, the present invention makes it possible to extrude not only endless belts of single-layer configuration but also those of multi-layer configuration in a good dimensional precision through one step and also in a short time. The fact that the extrusion can be made in a short time well suggests that mass production and low-cost production can be made.

In the case when the endless belt has a multi-layer configuration, at least one layer may contain the thermoplastic resin having a diphenyl sulfone structure represented by Formula (1).

Fig. 7 shows another extrusion apparatus for